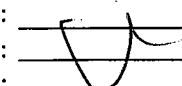
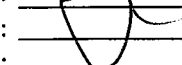


Date: Tuesday, 28/11/2006 10:09:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D26652
Job Number : 29719	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : D26652
This Issue : 28/11/2006 S.O. No. : N/A	Drawing Number : RTN 531
Print Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 29718	Material : N/A
Written By : 	Due Date : 05/12/2006 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 531



12/06/11/28

①

2.0	D26652	Saddle, RH, Fwd, Aft, Out
-----	--------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Saddle, RH, Aft, Out
 ORIGINAL B/N 23921

12/06/11/28

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 ID & STK
 USING NEW B/N

12/06/11/28

4.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

12/07/01/19

Job Completion



12/07/01/19

535

DART AEROSPACE LTD.	Work Order :	23921
Description: 206 Saddle, Outboard, Right Side	Part Number:	D2665-2
Drawing: D2665 Rev B	Qty:	12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>A</i>	05/08/07	12
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: <i>22241</i>	<i>P</i>	05/08/07	12
3	HAAS	Program batch number.	<i>NH</i>		12
4	QC	Inspect part number and batch number are programmed correctly. <i>23921</i>	<i>En</i>	05/08/07	12
5	HAAS	Fixturing W/O No. <i>NA</i> Fixturing Inspection last completed on _____ by _____			
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>P</i>	05/08/07	12
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>P</i>	05/08/07	12
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>P</i>	05/08/07	12
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>P</i>	05/08/07	12
12	METAL	Deburr	<i>En</i>	05/08/07	12
13	HAAS	Inspect Level 1	<i>P</i>	05/08/07	12
14	QC	Inspect Level 8	<i>En</i>	05/08/07	12
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>TCG</i>	05.09.30	12
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>SAD</i>	05/11/07	12
17	QC	Inspect Level 3	<i>ML</i>	05/12/15	12
18	STORES	Pack in foam, identify and stock. <i>Luc 363</i>	<i>CY</i>	05/12/16	12
19	EXPEDITING	Close Work Order Job Cost / Part <i>5uc 05/12/20 (12)</i>	<i>En</i>	05/12/20	12

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	<i>L</i>

RELEASED

EC DEC 18 2000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/27	# 11	SKID Tube Ridge slot milled 0.005" than 10 thin. 0.030" instead 0.035" 0.040"						
		See Attached sheet 05/09/27						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.120	.126	.126		
B	0.100	0.140		.125	.122	.124	.125		
C	0.100	0.140		.125	.125	.126	.126		
D	0.210	0.230		.218	.217	.218	.218		
E	1.245	1.255		1.250	1.250	1.257	1.250		
F	1.245	1.255		1.249	1.250	1.257	1.249		
G	5.990	6.010		6.002	6.003	6.002	6.003		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.680	1.680	1.680	1.680		
J	2.495	2.505		2.498	2.499	2.499	2.500		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		.235	0.240	0.240	0.240		
N	0.100	0.140		.106	.108	.109	.109		
O	0.540	0.560		.555	.551	.550	.551		
P	0.490	0.510		.496	.501	.502	.502		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.501	2.498	2.499	2.498		
S	0.240	0.270		.240	.241	.246	.246		
T	0.100	0.180		.140	.140	.140	.140		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.138	1.138	1.136	1.136		
W	1.565	1.585		1.576	1.576	1.575	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	05/09/16

Audited by:	<i>[Signature]</i>
Date:	05/02/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	0.123	0.123	0.122		
B	0.100	0.140		.125	0.121	0.121	0.123		
C	0.100	0.140		.125	0.126	0.126	0.125		
D	0.210	0.230		0.219	0.214	0.219	0.221		
E	1.245	1.255		1.250	1.246	1.247	1.249		
F	1.245	1.255		1.250	1.247	1.247	1.249		
G	5.990	6.010		6.002	6.002	6.003	6.002		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.681	1.675	1.676	1.676		
J	2.495	2.505		2.499	2.497	2.497	2.494		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		.106	0.107	0.107	0.107		
O	0.540	0.560		.549	0.547	0.548	0.546		
P	0.490	0.510		.501	0.499	0.498	0.497		
Q	3.609	3.619		3.612	3.609	3.610	3.609		
R	2.470	2.510		2.505	2.500	2.499	2.498		
S	0.240	0.270		.246	0.242	0.248	0.247		
T	0.100	0.180		.140	0.134	0.141	0.133		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.136	1.137	1.136	1.138		
W	1.565	1.585		1.576	1.575	1.574	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ED
Date:	05/08/27

Audited by:	ML
Date:	05/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	RF

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	0.120	0.121	0.120		
B	0.100	0.140		0.122	0.123	0.121	0.121		
C	0.100	0.140		0.123	0.122	0.122	0.123		
D	0.210	0.230		0.228	0.228	0.223	0.221		
E	1.245	1.255		1.246	1.248	1.248	1.248		
F	1.245	1.255		1.246	1.248	1.248	1.248		
G	5.990	6.010		6.001	6.001	6.001	6.003		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.676	1.677	1.677	1.678		
J	2.495	2.505		2.497	2.497	2.497	2.497		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.107	0.106	0.108	0.108		
O	0.540	0.560		0.544	0.545	0.545	0.545		
P	0.490	0.510		0.498	0.501	0.498	0.499		
Q	3.609	3.619		3.610	3.612	3.609	3.610		
R	2.470	2.510		2.498	2.499	2.499	2.500		
S	0.240	0.270		0.245	0.243	0.243	0.244		
T	0.100	0.180		0.133	0.139	0.139	0.138		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.138	1.140	1.141	1.140		
W	1.565	1.585		1.576	1.578	1.580	1.580		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

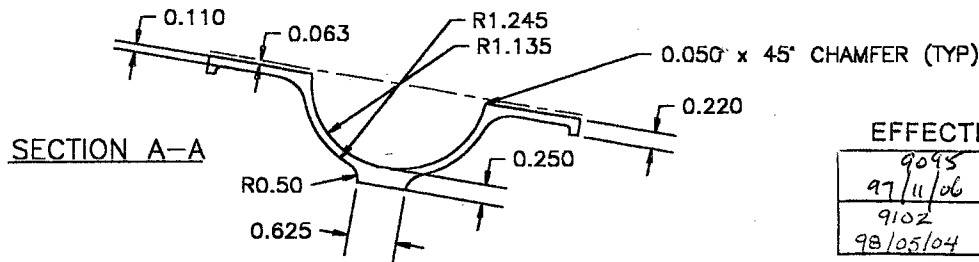
Measured by: <i>CP</i>
Date: 05/09/27

Audited by: <i>SN</i>
Date: 05/09/27

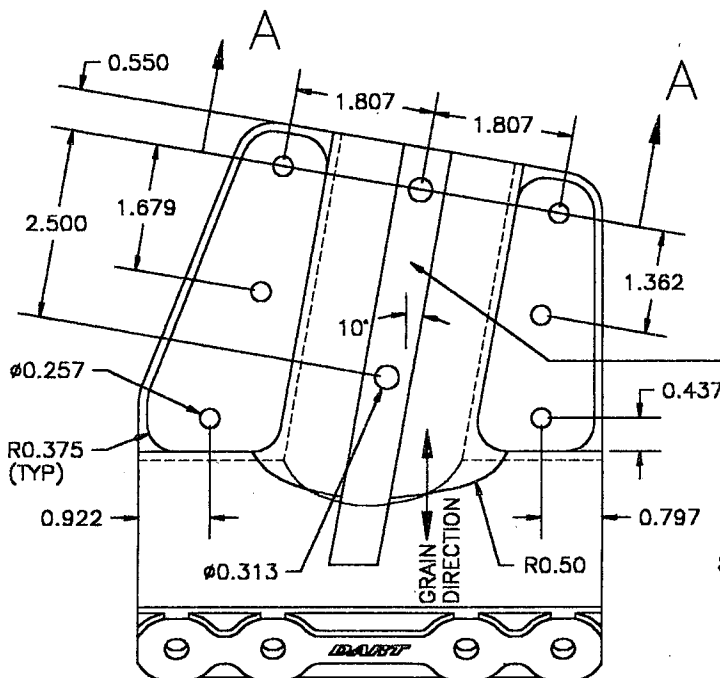
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	<i>#</i>



DESIGN <i>MEY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>MEY</i>	APPROVED <i>KE</i>	DRAWING NO. D2665	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	



EFFECTIVE	DEOs
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	

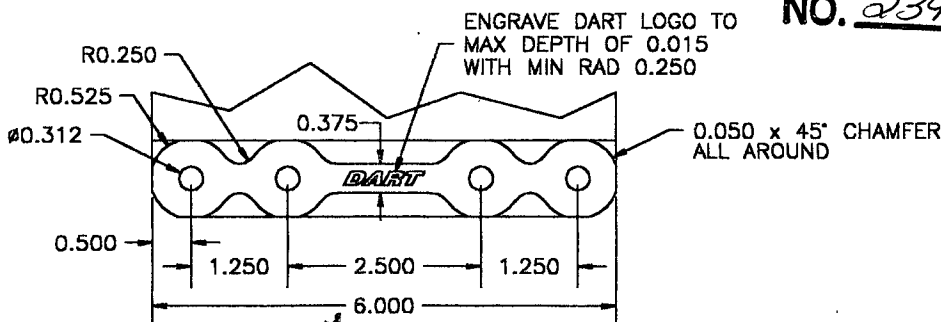
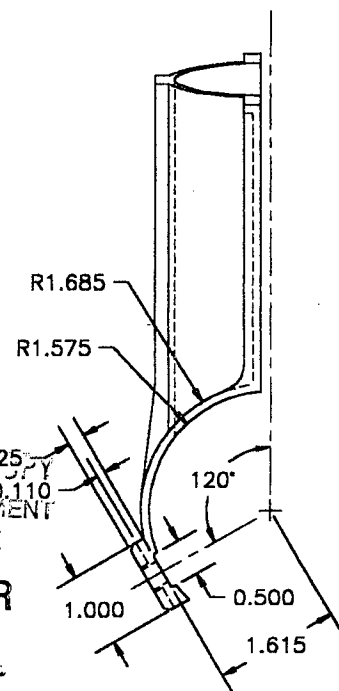


ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

SHOOT COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23921



ENGRAVE DART LOGO TO
MAX DEPTH OF 0.015
WITH MIN RAD 0.250

MATERIAL: ~~7075-T651~~ OR 7075-T7351 (QQ-A-250/12)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2665-1 SHOWN (D2665-2 IS OPPOSITE)

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
97/07/16 DS
ECN 008

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No	: 0023921	Department Code:	
Project Name	: D2665-2	Burden Flags	: NNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2665-2	Invoice Number	:
Description	: Saddle, RH, Fwd,Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

ATTN: ROBERTO @ 613-632-4443

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mtg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/27	11	SE/D Tube Ridge slot milled. Drawn ^{to} H.A. - 0.230 INSTEAD OF .235 0.240		ACCEPTABLE DEVIATION	 05.09.27	 05.09.27	 05.09.27	 05.09.27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:

Date: 05/12/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 11/14/2005 2:43:12 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, RH, 206
Job Number	: 23921		
Estimate Number	: 10523		
P.O. Number	:	Part Number	: D26652
This Issue	: 11/14/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2665 REV. B
First Issue	: / /	Project Number	:
Previous Run	: 24499	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 11/30/2005
Checked & Approved By	:	Qty:	12
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101003	7075-T7351 2X6.25X7.875
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
1- Program batch number
2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
5- Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

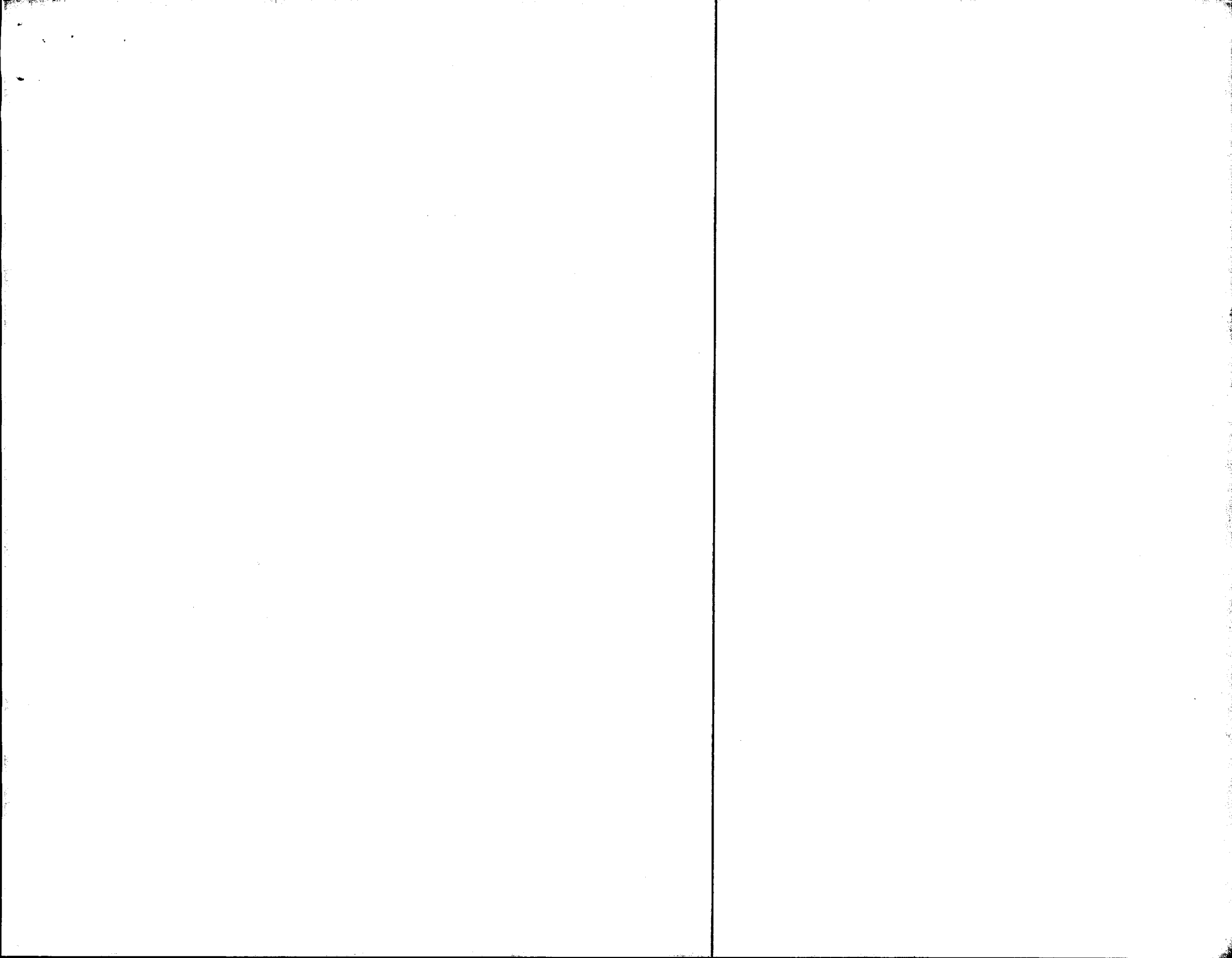


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK



Date: Monday, 11/14/2005 2:43:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 23921

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:44 am

Work Order No	: 0023921	Department Code:	
Project Name	: D2665-2 ✓	Burden Flags	: NNNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2665-2	Invoice Number	:
Description	: Saddle, RH, Fwd,Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-02-05		
Est Finish Date	: 08-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	23.50	100.00		
Production Cost	0.00	482.10	100.00	0.00	482.10
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	24.00	100.00		
CNC	0.00	111.48	100.00	0.00	111.48
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	593.58	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	593.58			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	(-593.58)

MS 013
u
11-14